

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002714**Date Inspected:** 21-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** Tower & OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

New Tower Shop Bay 2:

The QA Inspector randomly observed Submerged Arc Welding (SAW) being performed on Skin Plate Sub-Assemblies. No data recorded. The QA Inspector randomly observed ZPMC CWI An Qing Xiang. The QA Inspector was requested by the Lead QA Inspector, to go to the New OBG Bay 2 to perform final QA Visual (VT) Inspections on Deck Panels that had been repaired and that were on the "Hot Panel" List. The QA Inspector immediately left Bay 1 of the New Tower Shop.

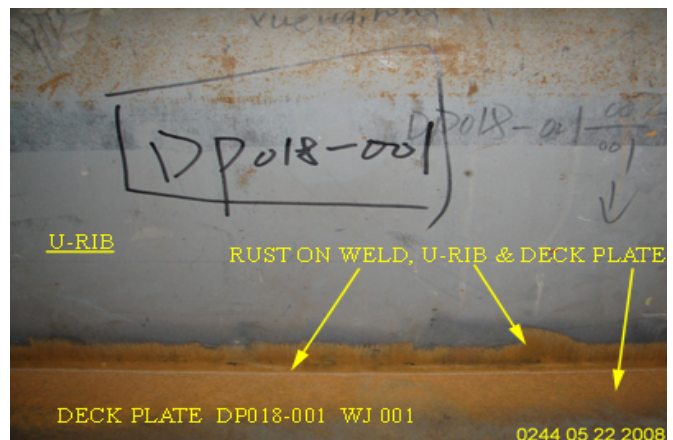
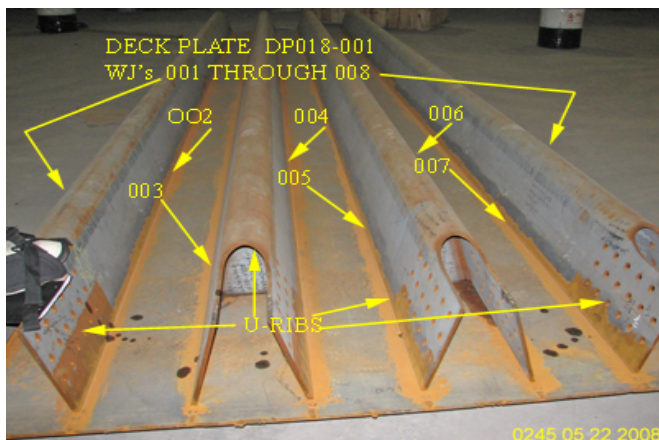
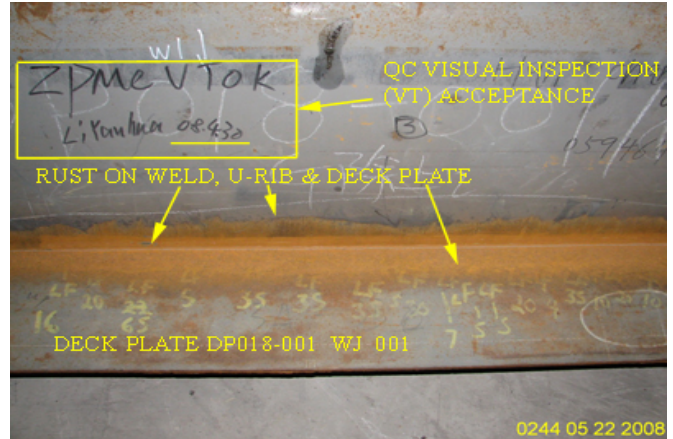
New OBG Bay 2:

The QA Inspector attempted to locate the Deck Panels on the "Hot Panel" List in order to perform final QA VT of the welds attaching the U-Ribs after the completion of repairs. The QA Inspector had been informed during turnover by the Swing Shift QA Personnel, that the "Hot Panel" List Deck Panels were in the New OBG Bay 2. The QA Inspector was able to locate 5 out of the 9 Deck Panels (DP) in The New OBG Bay 2. The QA Inspector located DP018-001 in the front (south) end of the New OBG Bay 2, but the welds were covered in rust and it was not ready for final QA VT. The QA Inspector observed that there were no other DP's located in the front (south) end of Bay 2. The QA Inspector located 4 more of the 9 DP's on the "Hot Panel" List in the back (north) end of Bay 2. DP016-001 was already marked as completed on 05-21-08 on the Day Shift. DP016-001 was also stacked

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on top of DP060-001, which was stacked on top of DP060-001 and made both of the latter DP's inaccessible for Final QA VT. The QA Inspector located DP057-001 in the same area as DP013-001, DP016-001 and DP060-001; but it had a large spreader bar complete with all of the rigging spread out all over the top of the Deck Panel; and made this DP also inaccessible for final QA VT. The QA Inspector searched several other areas and could not locate the other 4 DP's DP019-001, DP061-001, DP062-001 and DP064-001. The attached photographs provide additional detail.



Summary of Conversations:

There were no relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Franco, Charlie

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer